

Work Order ID 117735

117735

Page 1

Thursday, May 01, 2014 10:19:58 AM

Item ID: D3140-07

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Door

Stop *NS2*

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: CX Date: 14/05/01 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3140	Rev F								

100

0.00

100

Packaging

Memo

0.00

Packaging

Pick kit to ship to Delastek

CX 14/05/05

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

SEP 16 2014

GAS
06
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Page 2

Item ID: D3140-07

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/22/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
Purchasing		0.00							
Purchasing	Memo Issue P/O: <u>24037</u> Purchase Part Number: D3140-07 Supplier: Delastek ***Ship kit and make as per dwg*** Conformity Certificate and Process sheet required								
130	Receive & Inspect for Damage & Mat'l Certs	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC6- Inspect dimensions to drawing	0.00							
140									
QC	Memo	0.00							
Quality Control	Ensure a copy of certification of conformity and process sheet from Delastek is attached.								

CL 14/05/05 ①

14/9/16 ①

SM
14/9/17

DQA: _____ Date: _____



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FAULT CATEGORY

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Page 3

Item ID: D3140-07

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/22/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Identify as per dwg & Stock Location: CA

0.00

150

Packaging

Memo

0.00

Packaging

14-09-17

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

14/9/1714-9-17

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Picklist Print

Thursday, May 01, 2014 10:19:58 AM

Page 1

Work Order ID: 117735

117735

Parent Item: D3140-07

D3140-07

Parent Item Name: Door

Start Date: 5/1/2014

Required Date: 8/22/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.01.17 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3140-09		Manufactured	No			100	Each	4.0000	1	1			
D3140-09									**				
Doubler Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST156				4					
				53767				4					
D3140-91		Manufactured	No			100	Each	3.0000	1	1			
D3140-91									**				
Doubler													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				3					
				52203				3					
D3140-99		Manufactured	No			100	Each	3.0000	1	1			
D3140-99									**				
Doubler													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				3					
				36761				1					
				52632				2					
D3140-101		Manufactured	No			100	Each	3.0000	2	2			
D3140-101									**				
Doubler													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST027				3					
				78724				3					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Parent Item: D3140-07

D3140-07

Parent Item Name: Door

Start Date: 5/1/2014

Required Date: 8/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3140-103

Manufactured No

100

Each

2.0000

1

1

D3140-103

Doubler

**

02/14/05/05

Location

Loc Qty

Loc Code

CA

2

34377

2

D3140-105

Manufactured No

100

Each

4.0000

1

1

D3140-105

Doubler

**

02/14/05/05

Location

Loc Qty

Loc Code

ST028

4

78721

4

D3140-301

Manufactured No

100

Each

8.0000

1

1

D3140-301

Doubler

**

02/14/05/05

Location

Loc Qty

Loc Code

CA

8

78717

8

D3140-07 P

X1

117735 05/14/16 01

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WORK ORDER NON-CONFORMANCE / UPDATE



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Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	58218
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
09-09-2014	01-05-2014	24599	Michael Gregoire	PO24037	Net 30 days USA
Ship Via		F.O.B.	Salesperson		GST/PST
Fedex Freight LTL Collect		Point de départ	Melody Shapcott, ext. 235		
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC135-0017	Line #1 D3140-05 Door Left Non Assy (Grosse) U of M: Chaque DWG D3140 REV. F	
				Serial #	Lot #
				61667..	61667
1	0	1	DKC135-0018	Line #3 D3140-07 Door Left Non Assy (Petite) U of M: Chaque DWG D3140 REV. F	
				Serial #	Lot #
				61667.	61667.

DOCUMENT INCLUS



It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

Quality department

AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Jeudi, 2014-05-08 14:25:00
Utilisateur: marc dubé

Feuille de Procédé

8/9 juin

Client : DART US DART AEROSPACE
Numéro Job : 61667
Numéro : 3406
Numéro B.A. :
Cette fois : 2014-05-08 No. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 40733

Nom Dessin : DOOR KIT
Numéro Article : DKC135-0017/-0018
Numéro Dessin : D3140
Projet Numéro : DK-359
Révision dessin : F
Matériel : Fibercote E-761
Date Dûe : 2014-05-15
2014-05-18

Qté: 1 Ud UNITE

Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Client: D3140-05/-07

Process Sheet Rév.: 03 remplacer AAC0559 et
AAC0563 par AAC2032 et AAC1361 respectivement,
changé AC0883 et AC0884 par AAC1885 et AAC1887
respectivement à 2 endroits qui avait été oubliés

COPIE

Produit additionnel

Numéro Job:



Séq.: Machine ou Description :

1.0 OUTILLAGE Outillage nécessaire pour la job



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Moule N° B30-23000-01T
Patron de découpe N° B30-23000-57T
Patron de découpe N° B30-23000-61T
Patron de découpe N° B30-23000-63T
Patron de découpe N° B30-23000-71T
Patron de découpe N° B30-23000-73T
Patron de découpe N° B30-23000-75T
Patron de découpe N° B30-23000-77T
Patron de découpe N° B30-23000-79T
Gabarit de taillage N° B30-23000-05T (2 pièce) et N° B30-2300-03T
Forme de silicone N° B30-23000-07T

à enlever déjà dans IF
comme l'autre planning
DKC135-0017/-0020

9.05.14

2.0 AAC0054 AAC2384 Frekote #700-NC #710 NC

Comment Qty.: 0.030 UNITE(s)/Unit Total: 0.030 UNITE(s)
Frekote #700-NC N° de Lot: 1-44859-1

13.05.14

3.0 PRÉPARATION Préparation du moule



Comment Setup: 0.00Hrs/ Run: 130.0000Min Total Run : 2.1667Hrs

Faire la préparation du moule selon IF135-0001 et IG 0009

Cte: 1 date: 13/05/14








Seau:

2/13/05/2014

DELASTEK
73DELASTEK
56
















Date: Jeudi, 2014-05-08 14:25:00
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: DOOR KIT	
Numéro Job: 61667		Numéro: DKC135-0017-0018	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description:	
4.0	AMB0211	Epoxy prepreg E-761 style 7781	
Comment	Qty.: 12.30 VERGE(s)/Unit Total: 42.30 VERGE(s) 21.5 verges Epoxy prepreg E-761 style 7781 N° de Lot: 4575710A7		
5.0	DECOUPE	Découpe manuelle des pièces	
			
Comment	Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs Découpe des tissus pré-impregné E-761 en paquet de 10.5 pi* (7 Paquet = 24.5 verges) Quantité: 1 Date: 26-06-14 Sceau: 67 40 4450 N-S. DKC135-0017/0018 AMB0211		
6.0	DRAPAGE	Drilage	
			
Comment	Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run: 12.0000Hrs Faire le drilage de 3 plis de tissus E-761 (4 Paquets) selon IF135-0001 Quantité: 1 Date: 11/07/14 Sceau: 56 73 4102 N.T. voir plan pour découpe tissu		
7.0	AAC1885	Tissu à délaminer Release ply B	
Comment	Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s) Tissu à délaminer Release ply B # de Lot: N/A		
8.0	AAC1887	Wrighton 5200 Bleu P3	
Comment	Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s) Wrighton 5200 Bleu P3 # de Lot: N/A		
9.0	AC0885	Feutre de drainage N° Airweave N 10	
Comment	Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)		
10.0	AC0882	Sac à vide N° Stretchlon 700	
Comment	Qty.: 7.770 VERGE(s)/Unit Total: 7.770 VERGE(s)		
11.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment	Qty.: 2.0000 ROULEAU(s)/Unit Total: 2.0000 ROULEAU(s)		
12.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 180.0000Min Total Run: 3.0000Hrs Faire le bagging sur la pièce selon IF135-0001 et IG 0012 Quantité: 1 Date: 11/07/14 Sceau: 73 56 4102 N.T.		


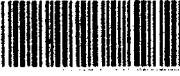


Date: Jeudi, 2014-05-08 14:25:00
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: DOOR KIT	
Numéro Job: 61667		Numéro DKC135-0017-0018	
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
13.0	CUISSON	Cuisson de pièce	
 			
Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs			
Faire la cuisson de la pièce selon IF135-0001, IG 0012 et PTN #20 N° de Cuisson: <u>8611</u>			
Quantité: <u>1</u> Date: <u>2-07-14</u> Sceau: 			
14.0	DÉMOULAGE	Démoulage de la pièce	
 			
Comment Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs			
Retirer le montage cuisson et faire les retouches de la pièces afin d'enlever les surplus de résines et les résidus de tissu à délaminer.			
Quantité: <u>1</u> Date: <u>8/07/14</u> Sceau:   			
15.0	INSPECTION	Inspection générale	
 			
Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs			
Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.			
Quantité: <u>1</u> Date: <u>8/07/14</u> Sceau: <u>4038 QA-3 1v</u>			
16.0	AAC1618	Rohacell 71S 1"thick 49.2" x 98.4" plain	
Comment Qty.: 2.000 FEUILLE(s)/Unit Total : 2.000 FEUILLE(s) Rohacell 71S 1"thick 49.2" x 98.4" plain N° de Lot: <u>1-45755-1</u>			
17.0	DECOUPE	Découpe manuelle des pièces	
 			
Comment Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs			
Faire la découpe des pièce de mousse structurales (Rohacell) sur la scie à ruban selon IF135-0001.			
Quantité: <u>1</u> Date: <u>20/06/14</u> Sceau:  			

Date: Jeudi, 2014-05-08 14:25:00
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: DOOR KIT	
Numéro Job: 61667		Numéro: DKC135-0017/-0018	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
18.0	SÉCHAGE/ANEAL	Séchage / Anealing	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le séchage du Rebacell selon IF135-0001 et les information du manufacturier. N° de Cuisson: 8568 et 8590			
Quantité: 1 Date: 13/09/14 Scéau: 			
19.0	AMB0442	Film adhesif EA9696 36" large x 0.06(psf)	
Comment Qty.: 6.12 VERGE CAR(s)/Unit Total: 6.12 VERGE CAR(s) 5.75 verges			
Film adhesif de EA9696 36" large x 0.06 (psf) 1-45751-2			
20.0	AAC2032	Core splice adhesive NB-51/301	
Comment Qty.: 5.0 PIED CARRE(s)/Unit Total: 5.0 PIED CARRE(s)			
Core splice adhesive NB-51/301 N° de Lot: 1-45752-1			
21.0	AAC1361	Putty AD Tech P-17	
Comment Qty.: 0.50 UNITE(s)/Unit Total: 0.50 UNITE(s)			
Putty AD Tech P-17 N° de Lot:			
22.0	AAC1630	N° D3140-09, Doubler	
Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)			
N° D3140-09, Doubler N° de Lot: 1-45913-7			
23.0	AAC1631	N° D3140-87, Doubler	
Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)			
N° D3140-87, Doubler N° de Lot: 1-45913-1			
24.0	AAC1632	N° D3140-91, Doubler	
Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)			
N° D3140-91, Doubler N° de Lot: 1-45913-8			
25.0	AAC1634	N° D3140-95, Doubler	
Comment Qty.: 3 UNITE(s)/Unit Total: 3 UNITE(s)			
N° D3140-95, Doubler N° de Lot: 1-45913-2			
26.0	AAC1635	N° D3140-97, Doubler	
Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)			
N° D3140-97, Doubler N° de Lot: 1-45913-3			
27.0	AAC1637	N° D3140-99, Doubler	
Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)			
N° D3140-99, Doubler N° de Lot: 1-45913-9			
28.0	AAC1638	N° D3140-101, Doubler	
Comment Qty.: 2 UNITE(s)/Unit Total: 2 UNITE(s)			
N° D3140-101, Doubler N° de Lot: 1-45913-10			



Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: DOOR KIT

Numéro Job: 61667

Numéro DKC135-0017/-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

29.0

AAC1639

N° D3140-103, Doubler

Comment

Qty.: 1 UNITE(s)/Unit

Total : 1 UNITE(s)

N° D3140-103, Doubler

N° de Lot:

1-45913-11

30.0

AAC1641

N° D3140-105, Doubler

Comment

Qty.: 1 UNITE(s)/Unit

Total : 1 UNITE(s)

N° D3140-105, Doubler

N° de Lot:

1-45913-12

31.0

AAC1643

N° D3140-241, Doubler

Comment

Qty.: 1 UNITE(s)/Unit

Total : 1 UNITE(s)

N° D3140-241, Doubler

N° de Lot:

1-45913-4

32.0

AAC1644

N° D3140-301, Doubler

Comment

Qty.: 2 UNITE(s)/Unit

Total : 2 UNITE(s)

N° D3140-301, Doubler

N° de Lot:

1-45913-5

33.0

NETTOYAGE

Nettoyage des pièces



Comment

Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le nettoyage des doublers selon IG 0063

Quantité: 1

Date: 14/08/14

Sceau:



34.0

ASSEMBLAGE

Assemblage mécanique



Comment

Setup: 960.0Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Mise en place des doublers et des pièces de mousse structurales selon IF135-0001

Quantité: 1

Date: 15-08-14

Sceau:



35.0

AAC1885

Tissu à délaminer Release ply B

Comment

Qty.: 4.37 VERGE(s)/Unit

Total : 4.37 VERGE(s)

36.0

AAC1887

Wrighton 5200 Bleu P3

Comment

Qty.: 7.18 VERGE(s)/Unit

Total : 7.18 VERGE(s)

37.0

AC0885

Feutre de drainage N° Airweave N 10

Comment

Qty.: 6.00 VERGE(s)/Unit

Total : 6.00 VERGE(s)

38.0

AC0882

Sac à vide N° Stretchlon 700

Comment

Qty.: 7.770 VERGE(s)/Unit

Total : 7.770 VERGE(s)

39.0

AC0886

Ruban à gommer jaune #: T/AT-200Y

Comment

Qty.: 2.0000 ROULEAU(s)/Unit

Total : 2.0000 ROULEAU(s)

Date: Jeudi, 2014-05-08 14:25:00

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: DOOR KIT

Numéro Job: 61667

Numéro DKC135-0017/-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

40.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le montage cuisson selon IF135-0001 et IG 0012

Quantité: 1

Date: 15-08-14

Sceau:



41.0

CUISSON

Cuisson de pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièces selon IF135-0001, IG 0012, et PTN #20 N° de

Cuisson: 8712

Quantité: 1

Date: 15-08-14

Sceau:



42.0

DÉMOULAGE

Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson de sur la pièce et enlever les résidu de ruban adhésif en teflon et les barre d'aluminium, garder seulement la barre qui sépare les deux pièces.

Quantité: 1

Date: 18/08/14

Sceau:



43.0

DECOUPE

Découpe manuelle des pièces



Comment Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs

Usinage des mousse structurales selon IF135-0001 et installer les doublers

Quantité: 1

Date: 21/08/14

Sceau:



44.0

INSPECTION

Inspection générale



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étapes.

Quantité: 1

Date: 21/08/14














Sceau:



Date: Jeudi, 2014-05-08 14:25:00

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: DOOR KIT	
Numéro Job: 61667		Numéro: DKC135-0017/-0018	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
45.0	AMB0211	Epoxy prepreg E-761 style 7781	
Comment	Qty.: 12.30 VERGE(s)/Unit Total: 12.30 VERGE(s) Epoxy prepreg E-761 style 7781 N° de Lot:		
46.0	DRAPAGE	Drapage	
			
Comment	Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run: 12.0000Hrs		
Drapage de la coquille intérieur selon IF135-0001 + plan de découpe et drapage			
Quantité:	1	Date: 22 Aout 14	Sceau:   
47.0	AAC1885	Tissu à délaminer Release ply B	
Comment	Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)		
48.0	AAC1887	Wrighton 5200 Bleu P3	
Comment	Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)		
49.0	AC0885	Feutre de drainage N° Airweave N 10	
Comment	Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)		
50.0	AC0882	Sac à vide N° Strechlon 700	
Comment	Qty.: 7.770 VERGE(s)/Unit Total: 7.770 VERGE(s)		
51.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment	Qty.: 2.0000 ROULEAU(s)/Unit Total: 2.0000 ROULEAU(s)		
52.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 180.0000Min Total Run: 3.0000Hrs		
Faire le montage cuisson selon IF135-0001 et IG 0012.			
Quantité:	1	Date: 25 Aout 14	Sceau:  
53.0	CUISSON	Cuisson de pièce	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs		
Faire la cuisson de la pièces selon IF135-0001, IG 0012, et PTN #20 N° de Cuisson: 8738			
Quantité:	1	Date: 25-08-14	Sceau: 

Date: Jeudi, 2014-05-08 14:25:00

Utilisateur: marc dubé

Feuille de Procédé

Cliant: DART US DART AEROSPACE

Nom Dessin: DOOR KIT

Numéro Job: 61667

Numéro DKC135-0017-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description:

54.0

DÉMOULAGE

Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson et faire des retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissu à délaminer

Retirer la pièce du moule

Quantité: 1

Date: 26/08/14

Sceau: 73



55.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le trimage de finition de la pièce selon IF135-0003

Quantité: 1

Date: 27/08/14

Sceau: 56



56.0

INSPECTION

Inspection generale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnel"

Quantité: 1

Date: 27/08/14

Sceau: 73



57.0

AAC1021

Dupont Primer N° 7704S

Comment Qty.: 0.5000 UNITE(s)/Unit Total: 0.5000 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-46475-2

58.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-46473-2

59.0

PRIMER

Application primer



Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire l'application du primer selon IG 0008.

Quantité: 1

Date: 27/08/14

Sceau: 73

N° Fiche


mélange: 6645

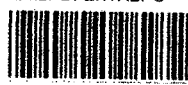
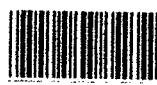
4349



Date: Jeudi, 2014-05-08 14:25:00
Utilisateur: marc dubé


Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	DOOR KIT
Numéro Job:	61667	Numéro	DKC135-0017/-0018
Numéro Job:			

# Séq.:	Machine ou Opération:	Description :
64.0	EMBAL / ENTREPO	Emballage & Entreposage
		
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs	
	Emballer et entreposer selon IG 0057	
Quantité:	Date: 9-9-14 Soeau: 4451	

N° Bon de travail: 61667

 N° pièce: DOOR KIT
 DKC135-0017/-0018

Article	Description	N° lot	Date de sortie	Heure de sortie	Temps restant Temp. Ambiante	Date expiration	Sceau employé
AAC1471	COPPER MESH						
AAC1541	CORE SPLICE						
AMB0211	EPOXY PREPREG	4575710A(RI)	25-06-14	14.30	720 H	23-12-14	
AMB0327	EPOXY PREPREG						
AMB0326	CARBONE						
AMB0442	FILM ADHÉSIF	1-45751-1	22-06-14	17:00	1440	22-05-15	